

Date: Wednesday, 3/12/2008 1:41:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING		
Job Number	: 37851		Part Number	: D23273		
Estimate Number	: 10826		Drawing Number	: D2327 REV D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/12/2008	S.O. No. :	Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: MACHINED PARTS			
Previous Run	: 37541		Due Date	: 4/4/2008		Qty: 50 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est. F 09.11.02 Removed 303 SS KJ/EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304R0375	304 SS ROUND BAR
Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s) Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375) Batch: M107403 MMF 08/04/10		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE MMF/mh/JF 08/04/10		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK RG 08/04/11		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 130411-26 8/4/14 50 50X		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER BUSHING

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/14 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37851
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

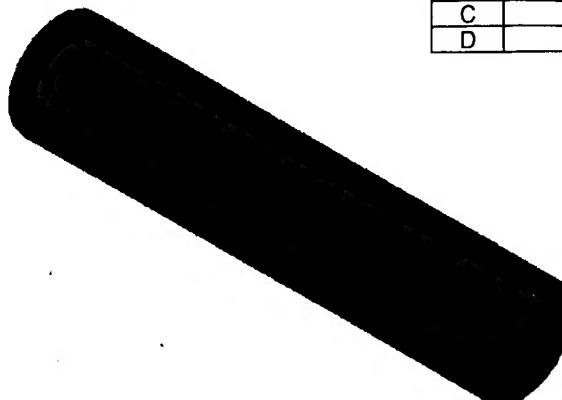
X First Article Prototype

Measured by: <u>MMF /mfl</u>	Audited by: <u>SG</u>	Prototype Approval:	N/A
Date: <u>08/04/09</u>	Date: <u>08.04.09</u>	Date:	N/A

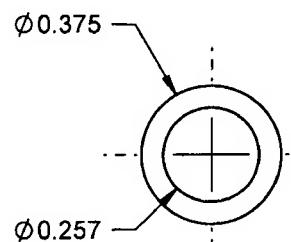
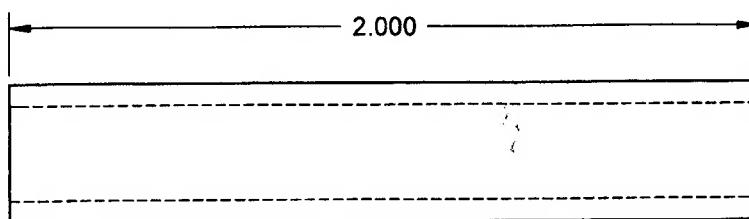
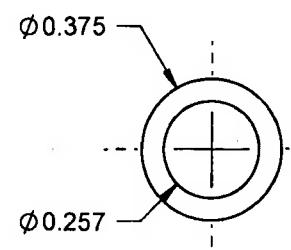
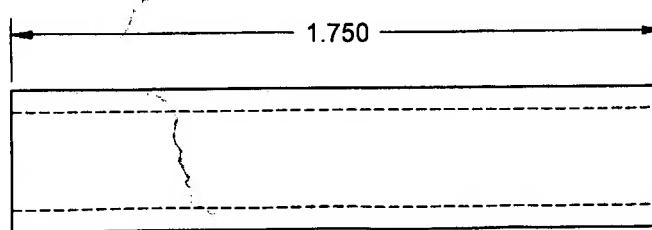
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



RELEASED

06.11.14 *CH***D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING**

37851

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø 0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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